

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2014-85 Date Opened: 01 Nov 2014 Title: FabricationAircraft OEM: Multiple Aircraft Model: Multiple Product Type: Handles Product Model: Multiple Quantity: 4/2**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification (Original)
Time Sheet (R&D)
Notes

Initial or N/A

| |
|-----|
| JR |
| N/A |
| JR |
| JR |
| N/A |
| N/A |
| N/A |
| N/A |

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

| |
|----|
| JR |
| JR |

Drawing List

| Drawing # | Rev # | Description | Initial or N/A |
|-----------|-------|--------------------|----------------|
| 84261 | 2 | Bar Assembly | JR |
| 84262 | 2 | Basket Handle Assy | JR |
| | | | |
| | | | |
| | | | |
| | | | |
| | | | |

Traveller

Initial or N/A

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|--|
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| |
| |
| |

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

| |
|-----|
| 4/2 |
| N/A |
| N/A |
| N/A |

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

| |
|-----|
| N/A |
| N/A |
| N/A |
| N/A |
| JR |
| JR |

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

| |
|-----|
| N/A |
| N/A |
| N/A |

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

| |
|-----|
| JR |
| N/A |
| N/A |

Work performed by:

Print: Jason RekveSign: Jason RekveSCA: AD01Date: 01-Nov-14

ICC / Dual Inspection performed by:

Print: Jeff ClarkeSign: Jeff ClarkeSCA: AD02Date: 01-Nov-14

Work Order closed by:

Print: Jason RekveSign: Jason RekveSCA: AD01Date: 01-Nov-14

Approved Manufacturing Facility 73-04

Form 20.0-03

Rev. Original 23 Sep 2014

CARGO BASKET HANDLE FABRICATION

General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2014-85

Complete
(initial or SCA #)

Date Open: 01-Nov-14

AD-05

1. Weld Lever Assembly – handle lever jig required
 - a. Set MS20615-4M3 monel rivet into socket in jig
 - b. Set 36274-01 bushing into socket in jig
 - c. Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
 - d. TIG weld around bushing using ER308L rod.
 - e. Fuse weld rivet to lever. Additional ER308L rod may be used if required.
 - f. Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
 - g. Record material POs on attached material list.

2. Clean up
 - a. Clean lever assembly by media blasting with glass bead.
 - b. Drill out lever bushing to O (0.316) on lathe:
 - i. Grasp bushing in chuck, ensure rivet clears between the jaws.
 - ii. Run at 300 RPM.
 - iii. Apply a drop of Rapid-Tap to drill.
 - c. De-burr.

3. Fabricate Handle Assembly
 - a. Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
 - b. Measure across TOP side of levers.
 - c. Cut handle tubing to length measured.
 - i. Handles under 40" long: 1.0" x 0.035 round tube
 - ii. Handles over 40" long: 1.0" x 0.065 round tube
 - d. De-burr tube.
 - e. Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
 - f. Record material PO on attached material list.

4. Weld Handle Assembly
 - a. Fuse tube to lever on both ends. Ensure levers are parallel.

5. Clean up
 - a. Clean welded area with scotch-brite.

6. Final Inspection –

To be completed by a different person than the previous steps.

 - a. Welds for complete and handle for fit.
 - b. Tag complete and inspected parts in preparation for installation.

AD-05

AK

JC



WO# 2014-85

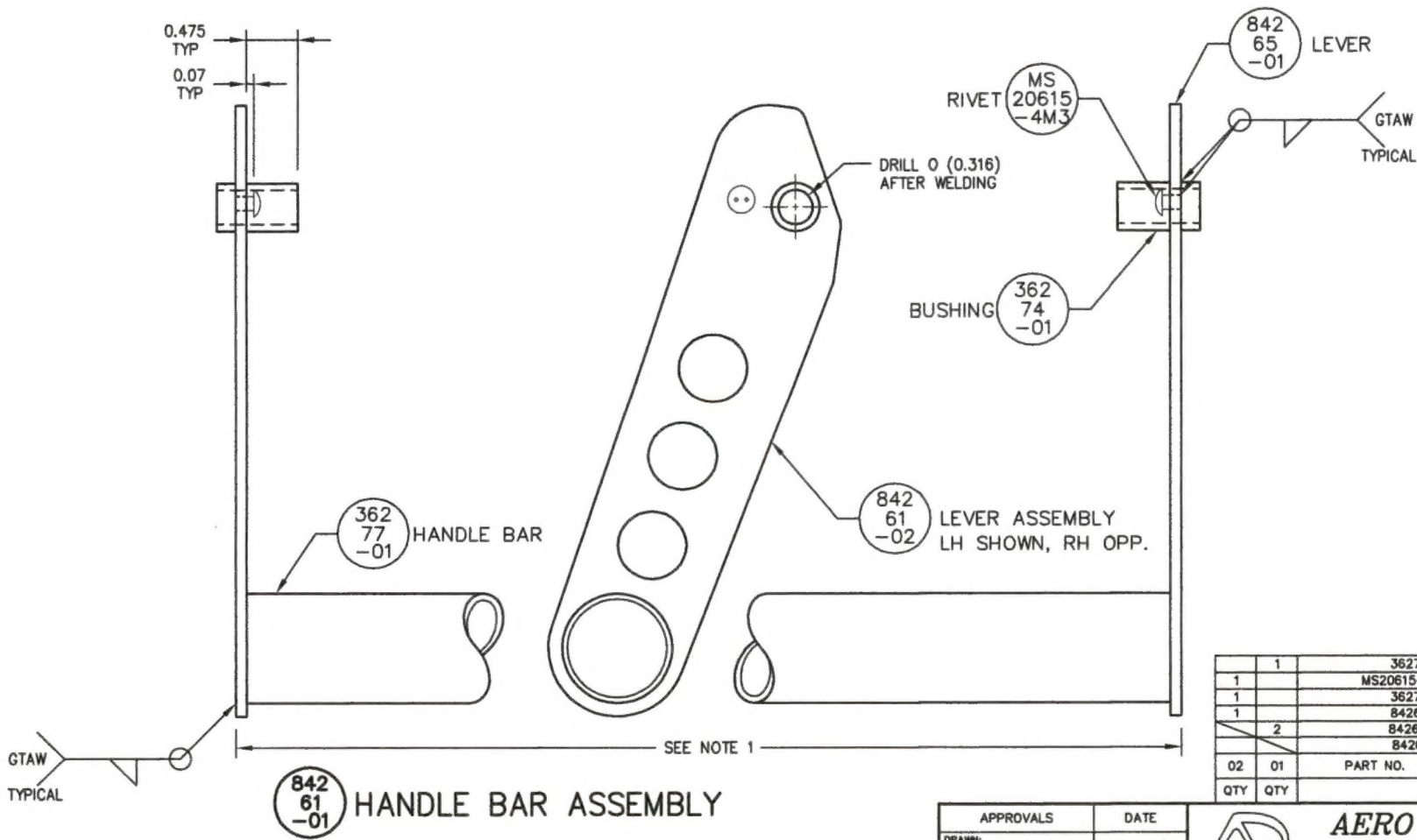
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Form 20.F.06

Rev. Original 27 May 2013

2014-85

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|---|--|----------|------------|
| REV. | DESCRIPTION OF CHANGE | INITIALS | DATE |
| 0 | INITIAL ISSUE | | |
| 1 | HANDLE END BRACKETS FLIPPED | BJC | SEPT 19/11 |
| 2 | TITLE BLOCK UPDATED; LEVER ASSEMBLY ASSIGNED P/N | BJC | MAR 13/14 |



- NOTES:
1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
 2. REMOVE ALL BURRS AND SHARP EDGES.
 3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

| QTY | QTY | PART NO. | DESCRIPTION |
|-----|-----|-------------|------------------------|
| 1 | | 36277-01 | HANDLE BAR |
| 1 | | MS20615-4M3 | RIVET (MONEL) |
| 1 | | 36274-01 | BUSHING |
| 1 | | 84265-01 | LEVER |
| 2 | | 84261-02 | LEVER ASSEMBLY (RH/LH) |
| 2 | | 84261-01 | HANDLE BAR ASSY |
| 02 | 01 | | |

| APPROVALS | | DATE | |
|--|-------------|------------|------|
| DRAWN: | R. RATHWELL | JUNE 18/09 | |
| CHECKED: | E. BURGAIN | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON: DECIMALS ANGLES X.XXX ±0.010 ±1/2° X.XX ±0.03 X.X ±0.1 | | | |
| AERO DESIGN LTD. 9888A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 804.488.8378 www.aerodesign.ca | | | |
| HELICOPTER CARGO BASKET HANDLE BAR ASSEMBLY | | | |
| SCALE 1 : 1 | DWG. SIZE | DWG. NO. | REV. |
| SHEET 1 OF 1 | A3 | 84261 | 2 |